

Date: Thursday, 31/01/2008 8:51:41 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : PLATE

Job Number : 37126

Estimate Number : 13144

P.O. Number :

This Issue : 31/01/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL /MED FAB

Previous Run :

Written By : W

Checked & Approved By :

Comment : Est Rev:A 08-01-30 new issue DD verified by:

Part Number : D3736041

Drawing Number : D3736 - U/R D3731 U/R

Project Number : N/A

Drawing Revision : U/R

Material :

Due Date : 07/02/2008

POSITIVE
RECALL

Qty: 10 Um: Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S125

6061-T6 .125 Sheet

Comment: Qty.: 0.0504 sf(s)/Unit Total : 0.5040 sf(s)

6061T6 aluminium sheet .125" thick

(M6061T6S125)

Batch: 105416 LB 8-1-31Loop per ECUK45

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3731

Dwg Rev: AProg Rev: ALB 8-1-31

2- Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Countersink holes as per dwg D3731

2- Deburr if necessary

MF 08-02-0508/02/04 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/01/2008 8:51:41 AM
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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/05 (X10)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

98 08-02-08 (X10)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.H. 08/02/08 (X10)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m/06379

FL 08/02/01 (18)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

68 08-02-11 (10)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

12.0 D37313 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
PLATE
batch B37124

SP 08/02/14 (10)

13.0 MS21059L3 Nut Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)
Nut Plate
batch M103965 (46)

14 M106042

M106042 (1)

U 08/02/14

POSITIVE RECALL
EFFECTIVE 08/02/01 AUTH 14
RELEASED DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/01/2008 8:51:41 AM
User: Linda Lacelle

Process Sheet

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Drawing Name: PLATE

Job Number: 37126

Part Number: D3736041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS20426AD35

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet

batch M4179

SIB 08/02/14

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3736

SAD 08/02/14

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

08/02/14

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

SCUP

PTD

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/04/14

POSITIVE RECALL

EFFECTIVE 08/31 AUTH

RELEASED DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/2/19	17	Task 1 for H41	U	8/2/19	1	U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

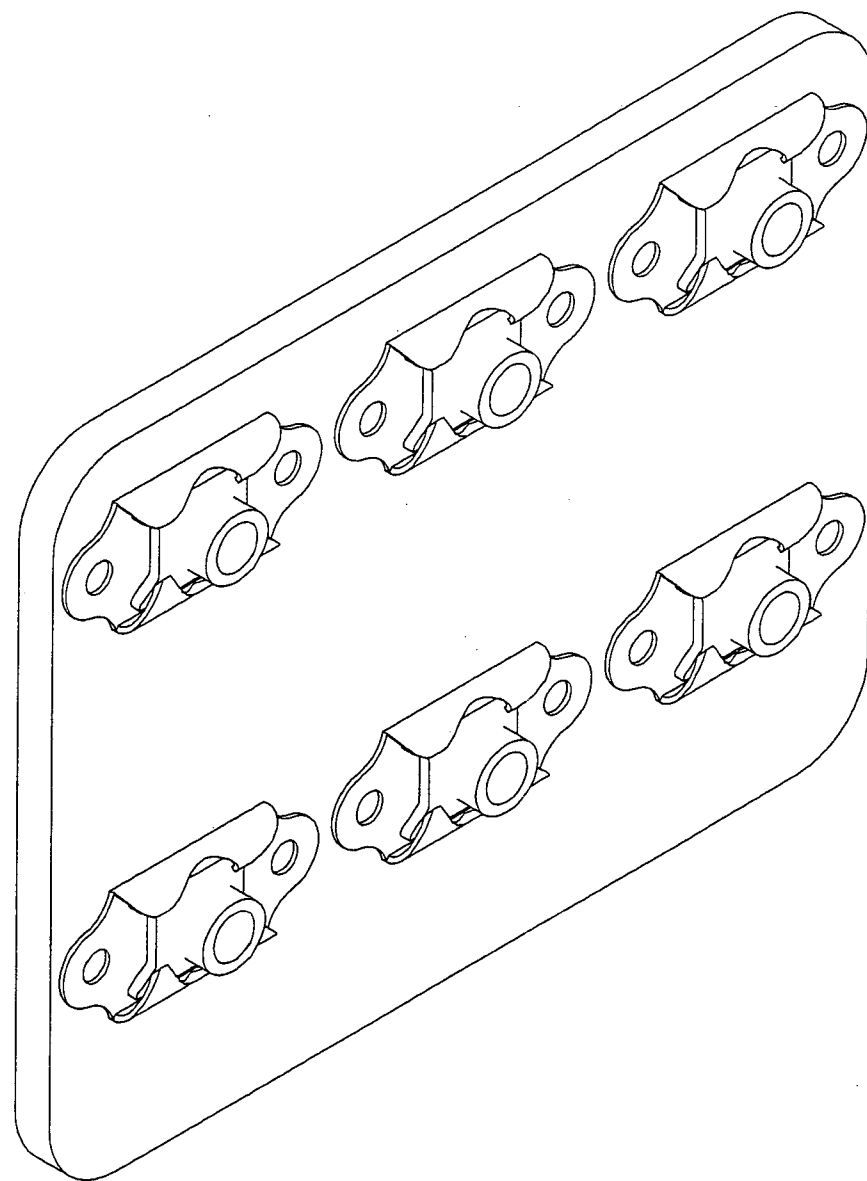
5

4

3

2

1



PRELIMINARY ISSUE
ASS 08.01.28

NOTES:

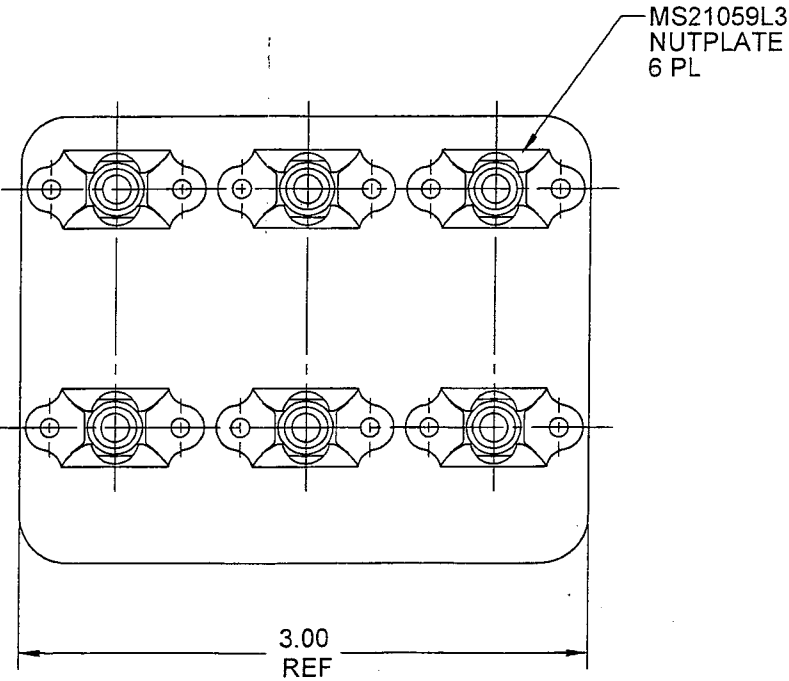
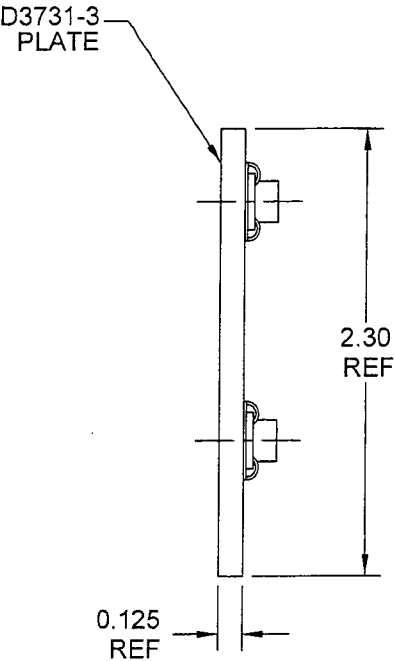
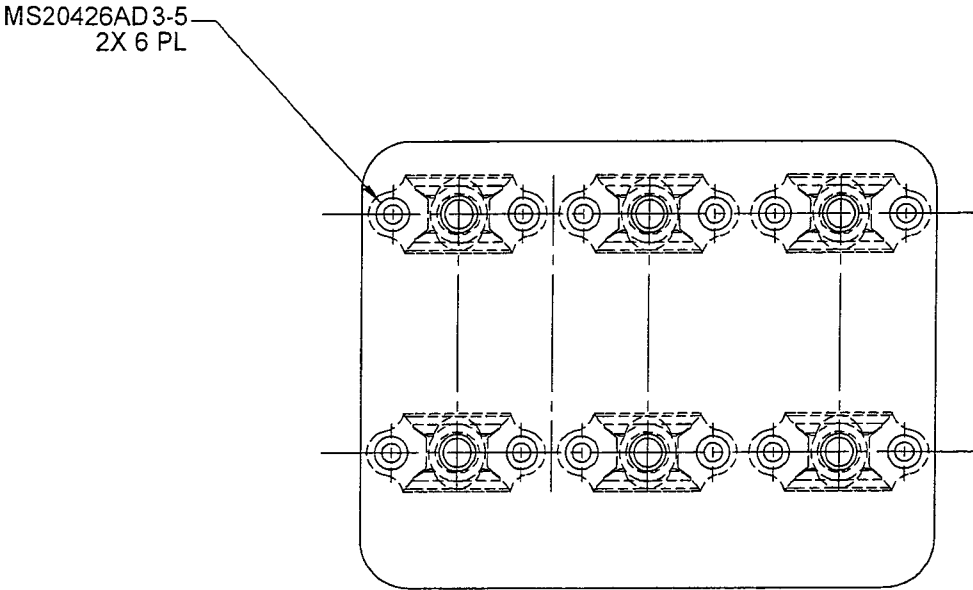
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3736-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.08 lbs

A	INITIAL RELEASE	AJS	08.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ILE	DRAWING NO.	REV. A
MFG. APPR.		D3736	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLATE ASSY	NTS
DATE	08.01.28	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PARTS LIST

QTY. -041	PART NUMBER	DESCRIPTION
X	D3736-041 <i>D3731-041</i>	PLATE ASSY
1	D3731- 4	PLATE
6	MS21059L3	NUT-PLATE
12	MS20426AD3-5	RIVET

PRELIMINARY ISSUE
ASS 08.01.28



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>AJS</i>	
CHECKED	<i>LE</i>	DRAWING NO. D3736
MFG. APPR.		REV. A SHEET 2 OF 2
APPROVED		TITLE PLATE ASSY
DE APPR.		SCALE 1:1
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DART AEROSPACE LTD		Work Order:	37126
Description:		Part Number:	D3731-3
Inspection Dwg: D3731-3 Rev: U/R			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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[illegible]

Measured by:	UB	Audited by:	↓	Prototype Approval:	ASS
Date:	8-1-31	Date:	08/01/31	Date:	08/01/31

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	